



PATENT ABSTRACTS OF JAPAN

(11) Publication number: **02204012 A**(43) Date of publication of application: **14.08.90**

(51) Int. Cl.

B29C 43/22
B29C 43/30
// B32B 31/20
B29K105:06

(21) Application number: **01024526**(22) Date of filing: **02.02.89**(71) Applicant: **SHOWA DENKO KK**

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(54) METHOD FOR CONTINUOUSLY FABRICATING
LAMINATED SHEET

(57) Abstract:

PURPOSE: To continuously produce the laminated sheet, for the lamination of which high pressurizing force is necessary, by a method wherein the application of pressure by pressurizing and heating plates and the release of pressure are performed alternately and periodically and the transfer of material to be fabricated is performed at the release of pressure.

CONSTITUTION: Only at the release of pressure of pressurizing plates 1, control signal to drive take-off rolls 6 is sent from a controlling section to a roll driving source so as to transfer material to be fabricated A, which is pinched between release films 7. The material to be fabricated A pinched between the pressurizing plates 1 is taken-off in order by the take-off rolls 6 and, at the same time, periodically applied by pressure with the pressurizing plates 1 so as to be deaerated. At the same time, the resin impregnated in base materials is hardened by receiving heat transmitted from the pressurizing plates 1, resulting in obtaining a laminated sheet B formed by the integral bonding of respective base materials. One cycle time ranging from the periodical application of pressure with

the pressurizing plates to the release of pressure is preferably shorter than one-fifth the set time of the thermosetting resin used therein.

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